



Dart Hawkesbury
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D4634-143
Job Sheet 167077-M



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Handing REV G

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	<i>D.M.L 18-2-17</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	<i>D.M.L 18-2-17</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	<i>D.M.L 18-2-17</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>FEB 21 2018</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>D.M.L</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>DAS 21 FEB 21 2018</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-3 <i>5043247</i>	1	2	0	0
	D4636-5 <i>5033877</i>	2	43	0	0
	D4647-1 <i>5033876</i>	1	4	0	0
	D4664-5 <i>5033875</i>	6	39	0	0
	D4712-1 <i>5033873</i>	2	4	0	0
	D4732-21 <i>5033872</i>	1	6	0	0
	D4732-25 <i>5033871</i>	1	7	0	0
	D5021-3 <i>F154854</i>	1	2	0	0
	MPNY-750S-9-C <i>5033869</i>	3	570	0	0
	MS20426AD3-4 <i>5033868</i>	4	5,055	0	0
	MS20426AD4-6 <i>5033867</i>	4	2,797	0	0
	MS21059L08 <i>5033866</i>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCI _____ Date : _____		DISPOSITION Rework ☐ Scrap ☐ Use as is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Master Unit 001000 Job No 167077 - M Container No: S043491 Part: D4634 - 143 Job No: 167077 - M Serial No/Batch: S043491 Revision: D4634 Inspector: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-8200 Email: sales@dartaero.com www.dartaero.com Date: 02/17/18		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval											
		Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____		Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	